

TEST REPORT

Report No.: D2596.01-501-47

Rendered to:

DECEUNINCK NORTH AMERICA, LLC
Monroe, Ohio

PRODUCT TYPE: PVC Casement Window, Type XOX
SERIES/MODEL: 141.194 CA-009

SPECIFICATIONS: AAMA/WDMA/CSA 101/I.S.2/A440-11, *NAFS - North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

AAMA/WDMA/CSA 101/I.S.2/A440-05, *Standard/Specification for Windows, Doors, and Unit Skylights.*

A440S1-09, Canadian Supplement to AAMA/WDMA/CSA 101/I.S.2/A440, *NAFS – North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

Test Dates: 10/29/13
Through: 11/12/13
Report Date: 12/27/13

SUMMARY OF RESULTS

Summary of Results		
Title	Test Specimen #1 <i>Non-reinforced Vent</i>	Test Specimen #2 <i>Reinforced</i>
AAMA/WDMA/CSA 101/I.S.2/A440-11 Rating	Class R-PG15 2743 x 1829 (108 x 72) - C	Class LC-PG35 2743 x1524 (108 x 60) - C
AAMA/WDMA/CSA 101/I.S.2/A440-05 Rating	C- R15 2743 x 1829 (108 x 72)	C- LC35 2743 x1524 (108 x 60)
Design Pressure	±720 Pa (±15.04 psf)	±1680 Pa (±35.09 psf)
Air Infiltration	0.1 L/s/m ² (0.02 cfm/ft ²)	<i>See Test Specimen #1</i>
Canadian Air Infiltration/Exfiltration Level	A3	<i>See Test Specimen #1</i>
Water Penetration Resistance Test Pressure	580 Pa (12.11 psf)	<i>See Test Specimen #1</i>

Summary of Results		
Title	Test Specimen #3 <i>Reinforced</i>	Test Specimen #4 <i>Reinforced</i>
AAMA/WDMA/CSA 101/I.S.2/A440-11 Rating	Class LC-PG30 2438 x 1829 (96 x 72) - C	Class LC-PG35 2438 x 1524 (96 x 60) - C
AAMA/WDMA/CSA 101/I.S.2/A440-05 Rating	C-LC30 2438 x 1829 (96 x 72)	C-LC35 2438 x 1524 (96 x 60)
Design Pressure	±1440Pa (±30.08 psf)	±1680 Pa (±35.09 psf)

Test Completion Date: 11/12/2013

Reference must be made to Report No. D2596.01-501-47, dated 12/27/13 for complete test specimen description and detailed test results. Reference Architectural Testing, Inc. Report No. D2398.01-501-47, dated 11/20/13 for complete *Gateway* test specimen description and test results.

1.0 Report Issued To: Deceuninck North America, LLC
351 North Garver Road
Monroe, Ohio 45050

2.0 Test Laboratory: Architectural Testing, Inc.
1140 Lincoln Avenue
Springdale, Pennsylvania 15144
724 275-7100

3.0 Project Summary:

3.1 Product Type: PVC Casement Window ,Type XOX

3.2 Series/Model: 141-194 CA-009

3.3 Compliance Statement: Results obtained are tested values and were secured by using the designated test method(s). The specimens tested successfully met the performance requirements for the following ratings. Reference Architectural Testing, Inc. Report No. D2398.01-501-47, dated 11/20/13 for complete *Gateway* test specimen description and test results.

Test Specimen No.	AAMA/WDMA/CSA 101/I.S.2/A440-11 Rating	AAMA/WDMA/CSA 101/I.S.2/A440-05 Rating
1	Class R-PG15 2743 x 1829 (108 x 72)- C	C-R15 2743 x 1829 (108 x 72)
2	Class LC-PG35 2743 x1524 (108 x 60)- C	C-LC35 2743 x1524 (108 x 60)
3	Class LC-PG30 2438 x 1829 (96 x 72)- C	C-LC30 2438 x 1829 (96 x 72)
4	Class LC-PG35 2438 x 1524 (96 x 60)- C	C-LC35 2438 x 1524 (96 x 60)

3.4 Test Dates: 10/29/2013 - 11/12/2013

3.5 Test Record Retention End Date: All test records for this report will be retained until December 27, 2017.

3.6 Test Location: Deceuninck North America, LLC test facility in Monroe, Ohio. Calibration of test equipment was performed by Architectural Testing in accordance with AAMA 205-01 "In-Plant Testing Guidelines for Manufacturers and Independent Laboratories".

3.0 Project Summary: (Continued)

3.7 Test Sample Source: The test specimens were provided by the client. Representative samples of the test specimen(s) will be retained by Architectural Testing for a minimum of four years from the test completion date.

3.8 Drawing Reference: The test specimen drawings have been reviewed by Architectural Testing and are representative of the test specimen(s) reported herein. Test specimen construction was verified by Architectural Testing per the drawings located in Appendix B. Any deviations are documented herein or on the drawings.

3.9 List of Official Observers:

<u>Name</u>	<u>Company</u>
Dean Erbaugh	Deceuninck North America, LLC
James Grippo	Architectural Testing, Inc.

4.0 Test Specification(s):

AAMA/WDMA/CSA 101/I.S.2/A440-11, *NAFS - North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

AAMA/WDMA/CSA 101/I.S.2/A440-05, *Standard/Specification for Windows, Doors, and Unit Skylights.*

A440S1-09, Canadian Supplement to AAMA/WDMA/CSA 101/I.S.2/A440, *NAFS - North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

5.0 Test Specimen Description:

5.1 Product Sizes:

Test Specimen #1:

Overall Area: 5.0 m ² (54.0 ft ²)	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	2743	108	1829	72
Operable vent size (2)	891	35-1/16	1786	70-5/16
Center fixed vent size	891	35-1/16	1786	70-5/16
Screen size (2)	829	32-5/8	1727	68

5.0 Test Specimen Description: (Continued)

5.1 Product Sizes: (Continued)

Test Specimen #2:

Overall Area: 4.2 m ² (45.0 ft ²)	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	2743	108	1524	60
Operable vent size (2)	891	35-1/16	1481	58-5/16
Center fixed vent size	891	35-1/16	1481	58-5/16
Screen size (2)	832	32-3/4	1421	55-15/16

Test Specimen #3:

Overall Area: 4.5 m ² (48.0 ft ²)	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	2438	96	1829	72
Operable vent size (2)	787	31	1786	70-5/16
Center fixed vent size	787	31	1786	70-5/16
Screen size (2)	729	28-11/16	1722	67-13/16

Test Specimen #4:

Overall Area: 3.7 m ² (40.0 ft ²)	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	2438	96	1524	60
Operable vent size (2)	787	31	1481	58-5/16
Center fixed vent size	787	31	1481	58-5/16
Screen size (2)	729	28-11/16	1421	55-15/16

5.0 Test Specimen Description: (Continued)

The following descriptions apply to all specimens.

5.2 Frame Construction:

Frame Member	Material	Description
Head, sill, jambs, and integral mullions	PVC	Extruded

	Joinery Type	Detail
All corners	Mitered	Thermally welded
Integral mullions	Coped/ butt type	Secured to the head and sill with six #8 x 3" long screws with sealing washers, three at each end.

5.3 Vent Construction: The fixed center vent was secured to the frame using #8 x 1-3/4" long screws with washers, three at each rail and and five at each stile (72" height units) (four at each stile 60" height units). The screws were evenly spaced and starting 5" from each corner. A PVC spacer was secured to each member of the fixed vent with two #8 x 3/4" long screws, one at each end.

Sash Member	Material	Description
All rails and stiles	PVC	Extruded

	Joinery Type	Detail
All corners	Mitered	Thermally welded

5.4 Weatherstripping:

Description	Quantity	Location
Co-extruded 0.250" diameter flexible vinyl bulb seal	1 Row	Vent perimeter, interior side
Co-extruded 0.280" high flexible fin	1 Row	Vent perimeter, at mid profile
0.400" high foam filled vinyl jacket leaf	1 Row	Vent perimeter, exterior side

5.0 Test Specimen Description: (Continued)

5.5 Glazing: *No conclusions of any kind regarding the adequacy or inadequacy of the glass in any glazed test specimen(s) can be made.*

Glass Type	Spacer Type	Interior Lite	Exterior Lite	Glazing Method
3/4" IG	Butyl, single sealed	3/32" annealed	3/32" annealed	Set from the exterior against a double-side adhesive tape and secured with rigid vinyl glazing beads.

Test Specimen	Quantity	Daylight Opening		Glass Bite
		millimeters	inches	
Test specimen #1	3	805 x 1705	31-11/16 x 67-1/8	1/2"
Test specimen #2	3	805 x 1397	31-11/16 x 55	1/2"
Test specimen #3	3	705 x 1705	27-3/4 x 67-1/8	1/2"
Test specimen #4	3	705 x 1397	27-3/4 x 55	1/2"

5.6 Drainage:

Drainage Method	Size	Quantity	Location
Weepslot	3/8" wide by 3/16" deep	6	Exterior face of bottom rails, , one 2-1/4" in from each end
Weepslot	3/8" wide by 3/16" deep	6	Bottom rail glazing pockets, one at each end

5.0 Test Specimen Description: (Continued)

5.7 Hardware:

Description	Quantity	Location
Rotary operator with metal guide track	2	Sill with guide track at bottom rail of operable vents
Multi point lever/lock stay bar system	2	Test Specimens #1 and #3: Mullions with four metal keepers on each stile of operable vents located 3-1/2", 22-1/2", 42-1/4" and 61-1/2" up from bottom. Test Specimens #2 and #4: Mullions with three metal keepers on each stile of operable vents located 3-1/2", 27" and 49-1/2" up from bottom.
Single arm concealed hinge with stainless steel guide track	4	Two per operable vent, top rail/ head and bottom rail/sill
Metal stud bracket	2	One per operable vent, bottom rails
Plastic ramp block	2	One per operable vent, bottom rails
Metal alignment snubbers	2 Sets	One per operable vent at the mid span of hinge stile / jamb

5.8 Reinforcement: Test specimen #1: No vent reinforcement was utilized.

Drawing Number	Location	Material
10500006	Test specimens #2, #3 and #4 All operable vent stiles	Extruded aluminum
10300028	All test specimens Mullions	Extruded aluminum

5.9 Screen Construction:

Frame Material	Corner Construction	Mesh Type	Mesh Attachment Method
Roll-formed aluminum	Square-cut with plastic corner keys	fiberglass	Flexible vinyl spline

6.0 Installation:

Each specimen was installed into a Spruce-Pine-Fir wood buck. The rough opening allowed for a 3/16" shim space. The nail fin perimeter of the window was sealed with a silicone sealant.

Location	Anchor Description	Anchor Location
Integral nail fin/ jambs	#8 x 5/8" long pan head screw	Nominally spaced at 14" on center, starting 1" from each end
Integral nail fin/ head and sill	#8 x 5/8" long pan head screw	Nominally spaced at 7" on center, starting 1" from each end

7.0 Test Results: The temperature during testing was 21.7°C (71°F). The results are tabulated as follows:

Test Specimen #1:

Title of Test	Results	Allowed	Note
Operating Force, per ASTM E 2068	Initiate motion: 45 N (10 lbf) Maintain motion: 13 N (3 lbf) Locks: 9 N (2 lbf)	60 N (13 lbf) max. 30 N (7 lbf) max. 100 N (22.5 lbf) max.	
Air Leakage, Infiltration per ASTM E 283 at 75 Pa (1.57 psf)	0.1 L/s/m ² (0.02 cfm/ft ²)	1.5 L/s/m ² (0.3 cfm/ft ²) max.	1
Air Leakage, Exfiltration per ASTM E 283 at 75 Pa (1.57 psf)	0.2 L/s/m ² (0.03 cfm/ft ²)	1.5 L/s/m ² (0.3 cfm/ft ²) max.	1
Canadian Air Infiltration/Exfiltration Level	A3	N/A	
Water Penetration, per ASTM E 547	N/A	N/A	3
Uniform Load Deflection, per ASTM E 330 taken at the right vertical mullion +720 Pa (+15.04 psf) -720 Pa (-15.04 psf)	11.4 mm (0.45") 14.2 mm (0.56")	Report Only.	4, 6, 7
Uniform Load Structural, per ASTM E 330 taken at the right vertical mullion +1080 Pa (+22.56 psf) -1080 Pa (-22.56 psf)	0.5 mm (0.02") 1.3 mm (0.05")	7.1 mm (0.28") max. 7.1 mm (0.28") max.	5, 6
Forced Entry Resistance, per ASTM F 588, Type: B- Grade: 10	Pass	No entry	
Thermoplastic Corner Weld	Pass	Meets as stated	
Insect Screen Serviceability per NAFS Canadian Supplement (A440S1-09) 60 N (13.5 lbf)	Pass	Meets as stated	

7.0 Test Results: (Continued)

Test Specimen #1: (Continued)

Title of Test	Results	Allowed	Note
Sash Vertical Deflection 200 N (45 lbf)	1.5 mm (.06")	17.8 mm (0.70") max.	
Distributed Load 300 Pa (6.27 psf)	Pass	No damage	
Optional Performance			
Water Penetration, per ASTM E 547at 580 Pa (12.11 psf)	Pass	No leakage	

Test Specimen #2:

Title of Test	Results	Allowed	Note
Optional Performance			
Uniform Load Deflection, per ASTM E 330 taken at the right vertical mullion +1680 Pa (+35.09 psf) -1680 Pa (-35.09 psf)	14.2 mm (0.56") 15.2 mm (0.60")	Report Only	4, 6, 7
Uniform Load Structural, per ASTM E 330 taken at the right vertical mullion +2520 Pa (+52.63 psf) -2520 Pa (-52.63 psf)	0.5 mm (0.02") 1.8 mm (0.07")	6.1 mm (0.24") max. 6.1 mm (0.24") max.	5, 6

Test Specimen #3:

Title of Test	Results	Allowed	Note
Optional Performance			
Uniform Load Deflection, per ASTM E 330 taken at the right vertical mullion +1440 Pa (+30.08 psf) -1440 Pa (-30.08 psf)	23.3 mm (0.92") 25.1 mm (0.99")	Report Only	4, 6, 7
Uniform Load Structural, per ASTM E 330 taken at the right vertical mullion +2160 Pa (+45.11 psf) -2160 Pa (-45.11 psf)	1.5 mm (0.06") 1.8 mm (0.07")	7.1 mm (0.28") max. 7.1 mm (0.28") max.	5, 6

7.0 Test Results: (Continued)

Test Specimen #4:

Title of Test	Results	Allowed	Note
Optional Performance			
Uniform Load Deflection, per ASTM E 330 taken at the right vertical mullion +1680 Pa (+35.09 psf) -1680 Pa (-35.09 psf)	12.2 mm (0.48") 14.2 mm (0.56")	Report Only	4, 6, 7
Uniform Load Structural, per ASTM E 330 taken at the right vertical mullion +2520 Pa (+52.63 psf) -2520 Pa (-52.63 psf)	1.0 mm (0.04") 1.3 mm (0.05")	6.1 mm (0.24") max. 6.1 mm (0.24") max.	5, 6

Note 1: The tested specimen meets (or exceeds) the performance levels specified in AAMA/WDMA/CSA 101/I.S.2/A440 for air leakage resistance.

Note 2: With and without insect screen.

Note 3: The client opted to start at a pressure higher than the minimum required. Test results are reported under Optional Performance.

Note 4: The deflections reported are not limited by AAMA/WDMA/CSA 101/I.S.2/A440 for this product designation. The deflection data is recorded in this report for special code compliance and information only.

Note 5: Loads were held for 10 seconds.

Note 6: Tape and film were used to seal against air leakage during structural testing. In our opinion, the tape and film did not influence the results of the test.

Note 7: Loads were held for 52 seconds

Architectural Testing will service this report for the entire test record retention period. Test records that are retained such as detailed drawings, datasheets, representative samples of test specimens, or other pertinent project documentation will be retained by Architectural Testing, Inc. for the entire test record retention period.

This report does not constitute certification of this product nor an opinion or endorsement by this laboratory. It is the exclusive property of the client so named herein and relates only to the specimen(s) tested. This report may not be reproduced, except in full, without the written approval of Architectural Testing, Inc.

For ARCHITECTURAL TESTING, Inc.

James P. Grippo
Technician

Lynn George
Director- Regional Operations

JPG:sld

Attachments (pages): This report is complete only when all attachments listed are included.

Appendix-A: Alteration Addendum (1)

Appendix-B: Drawings (9)



Test Report No.: D2596.01-501-47
Report Date: 12/27/13

Appendix A
Alteration Addendum

Note: No alterations were required.



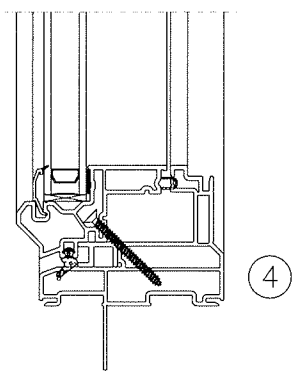
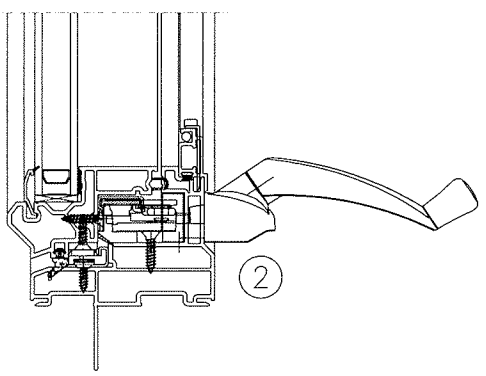
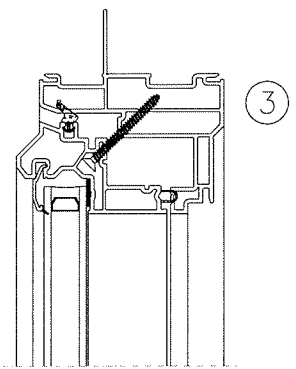
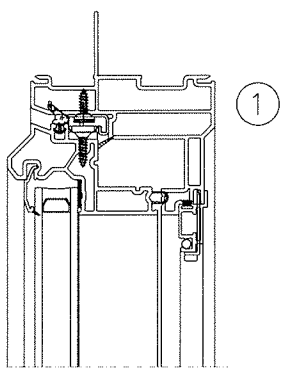
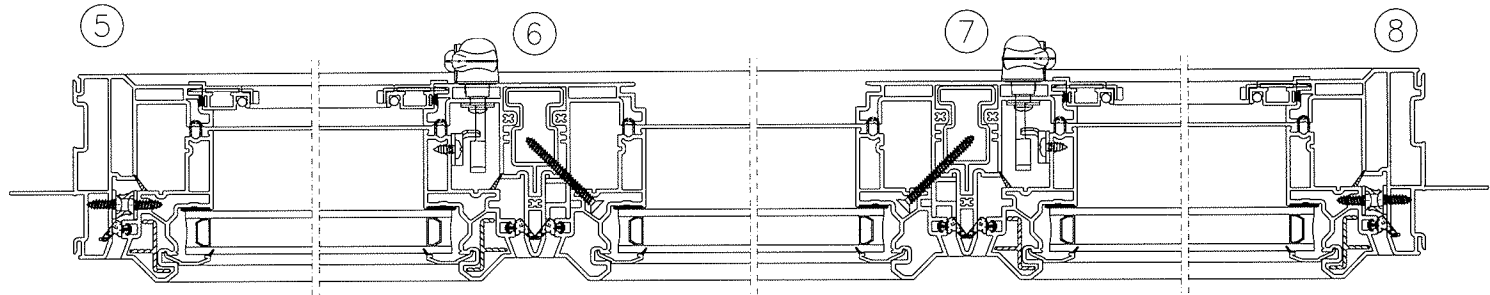
Test Report No.: D2596.01-501-47
Report Date: 12/27/13

Appendix B

Drawings

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

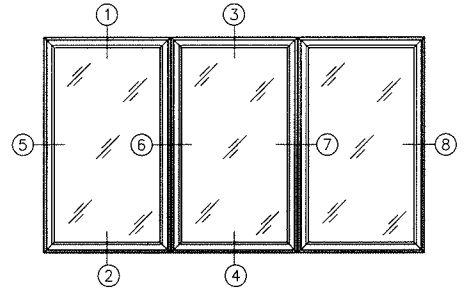
REV	DESCRIPTION	DATE	APPROVED
0	MOODY SCREEN TRACK	06/24/14	DM



Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# D2596.01
Date 12/11/13 Tech JG



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	<p>THIRD ANGLE PROJECTION</p>	<p>SCALE: 1/4" = 1'-0"</p>	<p>PROJECT: 141J94 CA - 009</p>	<p>DATE: 12/11/13</p>
	<p>PROJECT: 141J94 CA - 009</p>	<p>DATE: 12/11/13</p>	<p>PROJECT: 141J94 CA - 009</p>	<p>DATE: 12/11/13</p>
	<p>PROJECT: 141J94 CA - 009</p>	<p>DATE: 12/11/13</p>	<p>PROJECT: 141J94 CA - 009</p>	<p>DATE: 12/11/13</p>

Casement - XOX

DECEUNINCK MODEL NO.

141.194 CA - 009

deceuninck

		Part No.	Vendor	Material ex. Vinyl, Alum, Composite	Type ex. Rivot / Screw	Fastener			
						Qty	Size ex. #4, #6, #8, etc.	Length	Head ex. Pan, Flat, Oval, etc.
Frame									
	Head	10008056	Deceuninck	Vinyl					
	Frame Adapter - Head (if applicable)								
	Jamb	10008056	Deceuninck	Vinyl					
	Sill	10008056	Deceuninck	Vinyl					
	Mullion	10005739	Deceuninck	Vinyl					
	Frame Adapter - Sill (if applicable)								
Sash	<i>Fixed Lite Single-PI200-A</i>								
	Top Rail	10005484	Deceuninck	Vinyl					
	Lock Stile	10005484	Deceuninck	Vinyl					
	Hinge Stile	10005484	Deceuninck	Vinyl					
	Bottom Rail	10005484	Deceuninck	Vinyl					
	Glazing Bead	10005473	Deceuninck	Vinyl					
Hardware									
	Glass Thickness	3/4" IG		Glass					
	Operator								
	Hinge								
	Keeper								
	Lock Handle								
	Tie Bar or Lock Bar Guides								
	Snubber								
Reinforcement	(if applicable)								
	Frame								
	Mullion	10300028		Aluminum					
	Panel Stiles	10500006		Aluminum					
	Sash (large hollow)								
	Sash (small hollow)								

A print and CAD (dxf) drawing for any non-Deceuninck parts (i.e. glazing beads, reinforcements, bulb seals, balance covers, screen adapters, etc.), except glass and hardware components must be emailed along with a copy of this completed form to Deceuninck for the testing process to begin.

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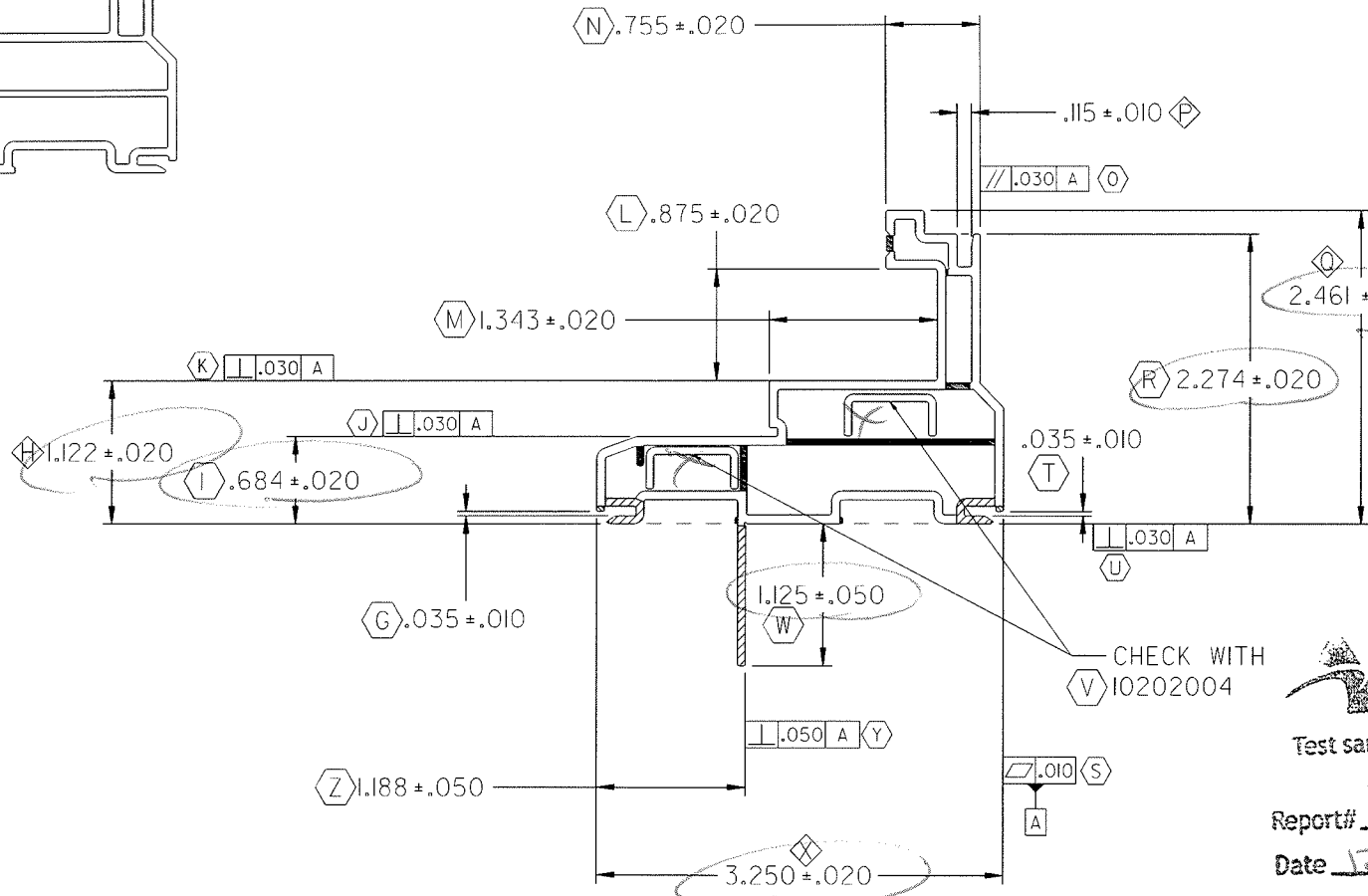
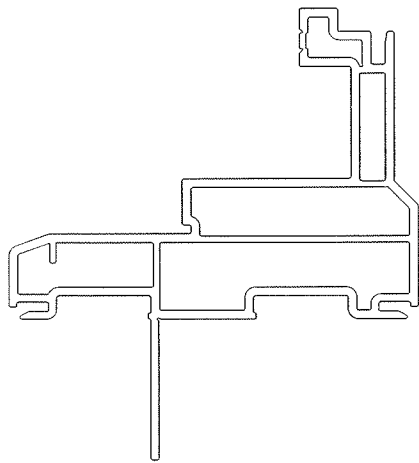
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Architectural Testing
 Test sample complies with these details.
 Deviations are noted.
 Report# DZ596.01
 Date 12/11/13 Tech JG

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
H	MOVED DATUM TO THE SIDE	10/11/23	BWB

KEY PRODUCT CHARACTERISTICS	
\diamond H	DIMENSION 1.102 - 1.142
\diamond P	DIMENSION .105 - .125
\diamond Q	DIMENSION 2.441 - 2.481
\diamond X	DIMENSION 3.230 - 3.270



WALL THICKNESS

.070	[Pattern]
.062	[Pattern]
.060	[Pattern]
.050	[Pattern]

Architectural Testing
 Test sample complies with these details.
 Deviations are noted.
 Report# D2596.01
 Date 12/11/13 Tech JG

NOTES:

1. 'STD00013' STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY \diamond A
2. INTERPRET ALL TOLERANCE APPLICATIONS PER STD00013 \diamond B
3. UNSPECIFIED EXTERNAL RADII = .XXX +.010 / -.005 \diamond C
4. UNSPECIFIED INTERNAL RADII = .XXX +.020 / -.005 \diamond D
5. UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- 10% \diamond E
6. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- 20% \diamond F

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UNLESS OTHERWISE SPECIFIED
 DIM ARE IN INCHES
 TOL ON ANGLES = 1°
 2 PL: ± 0.010° 3 PL: ± 0.005°
 INTERPRET DIM AND TOL PER
 ASME Y14.5M - 1994

THIRD ANGLE PROJECTION

DESIGN BY: RH
 DATE: 99/07/19
 DRAWN BY: RH
 DATE: 99/07/19
 AUTH: DATE:
 AUTH: DATE:
 AUTH: DATE:
 FILENAME:
 \$FILE NAME\$



NAME:
 MAIN FRAME - CA

SIZE DWG. NO: 10008056.SH
 SCALE: 1:1 | LBS/FT.J .696 | SHEET: 1 OF 1

SP/UDATES

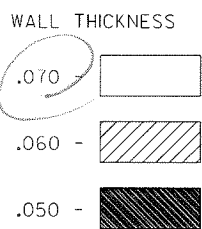
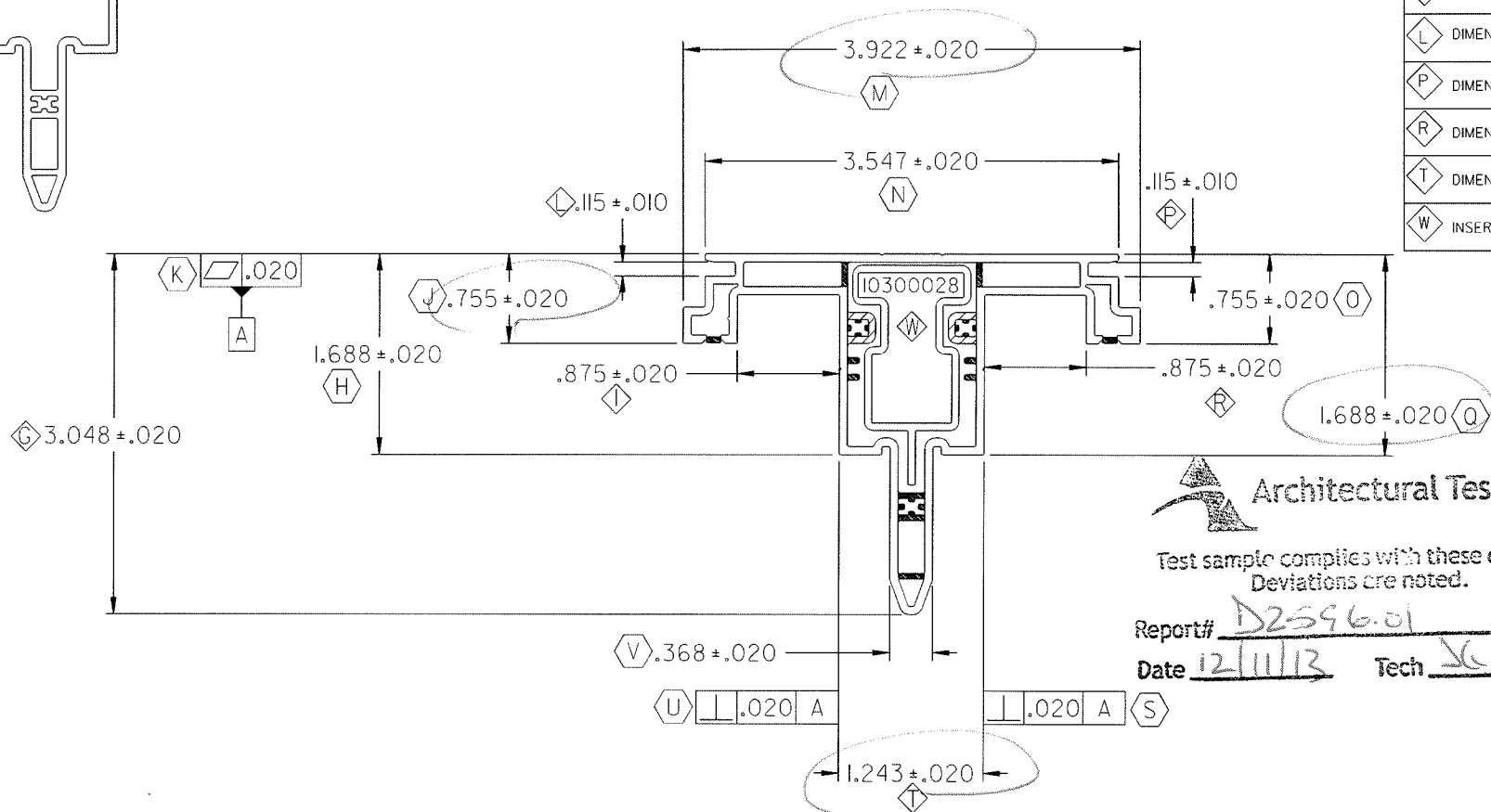
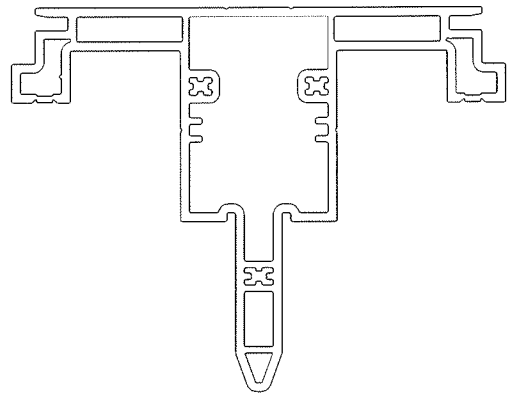
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REV. H

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
A	KPC	11/02/15	BWB

KEY PRODUCT CHARACTERISTICS	
G	DIMENSION 3.028 - 3.068
I	DIMENSION .855 - .895
L	DIMENSION .105 - .125
P	DIMENSION .105 - .125
R	DIMENSION .855 - .895
T	DIMENSION 1.223 - 1.263
W	INSERT I0300028



Architectural Testing
 Test sample complies with these details.
 Deviations are noted.
 Report# D2596.01
 Date 12/11/13 Tech JG

- NOTES:
- 'STD00013' STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY A
 - INTERPRET ALL TOLERANCE APPLICATIONS PER STD0013 B
 - UNSPECIFIED EXTERNAL RADII = .XXX +.010 / -.005 C D
 - UNSPECIFIED INTERNAL RADII = .XXX +.020 / -.005 E F
 - UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- 10%
 - UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- 20%

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UNLESS OTHERWISE SPECIFIED
 DIM ARE IN INCHES
 TOL ON ANGLES • 1°
 2 PL: • 0.010° 3 PL: • 0.005°
 INTERPRET DIM AND TOL PER
 ASME Y14.5M - 1994

THIRD ANGLE PROJECTION

DESIGN BY:	VH
DATE:	00/01/19
DRAWN BY:	CH
DATE:	00/01/19
AUTH:	DATE:
AUTH:	DATE:
AUTH:	DATE:
FILENAME:	
	110527

deceuninck NORTH AMERICA

351 NORTH GARVER ROAD
 MONROE, OHIO 45002

NAME: CENTER BAR FRAME

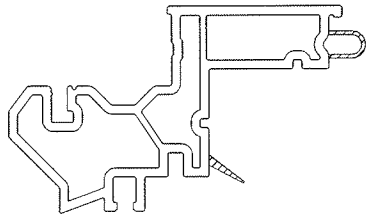
SIZE DWG. NO: B | 10005739.SH | REV: A

SCALE: 1/4" = 1" (LBS/F.T.) .803 SHEET: 1 OF 1

\$PL0DATES \$USERS \$REV

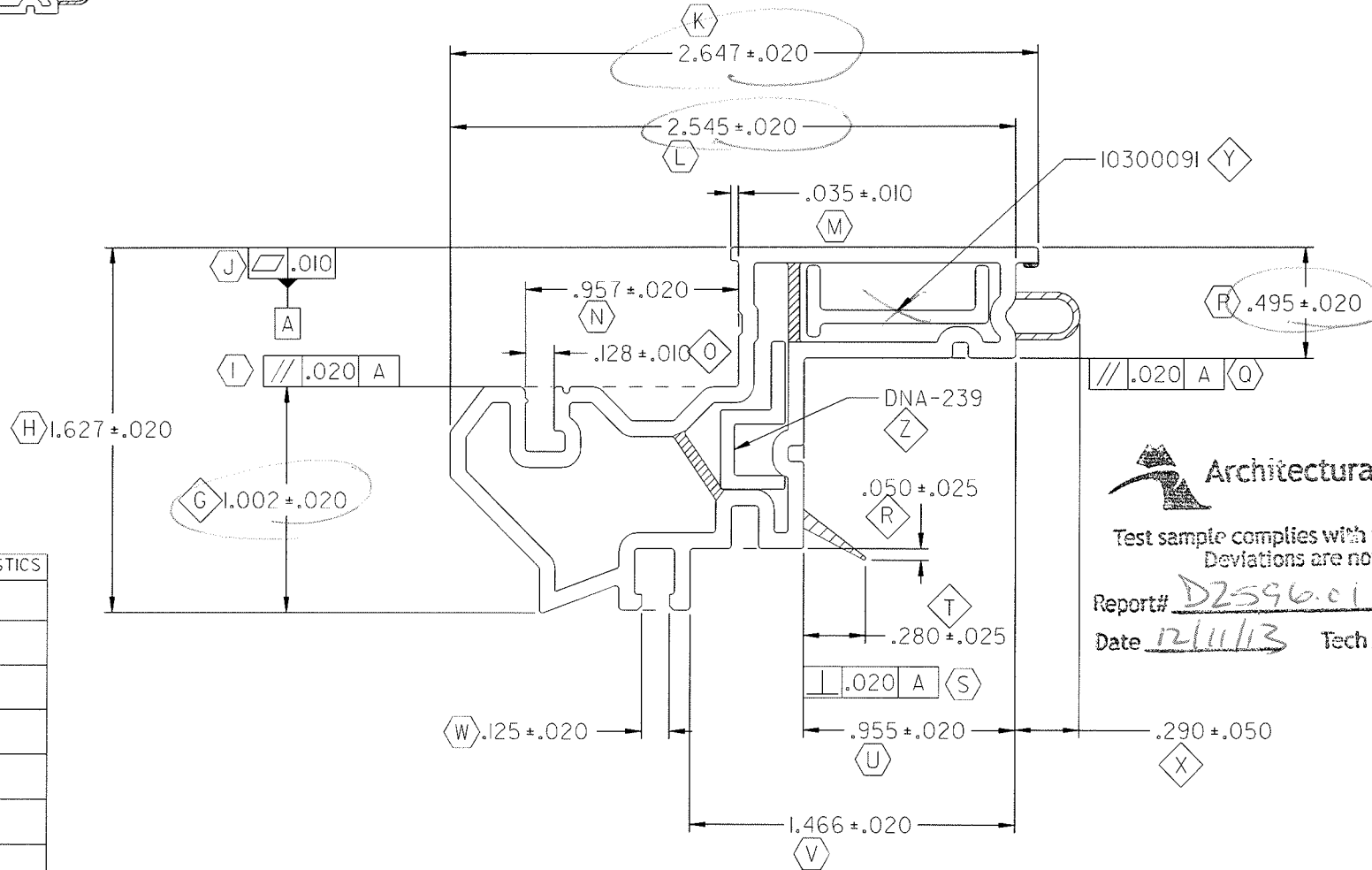
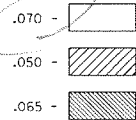
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
J	ADDED MYLAR	10/03/17	BWB



SCALE 1:1

WALL THICKNESS



KEY PRODUCT CHARACTERISTICS

G	DIMENSION .982 - 1.022
O	DIMENSION .118 - .138
R	MYLAR 10005484_0P REV E
T	MYLAR 10005484_0P REV E
X	MYLAR 10005484_0P REV E
Y	ALUM INSERT 10300091
Z	GAUGE DNA-239

Architectural Testing
 Test sample complies with these details.
 Deviations are noted.
 Report# D2596.01
 Date 12/11/13 Tech JG

- NOTES:
- 'STD00013' STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY (A)
 - INTERPRET ALL TOLERANCE APPLICATIONS PER STD0013
 - UNSPECIFIED EXTERNAL RADII = .XXX +.010 / -.005 (B, C)
 - UNSPECIFIED INTERNAL RADII = .XXX +.020 / -.005 (D, E)
 - UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- 10% (F)
 - UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- 20% (F)

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UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES
 TOL ON ANGLES = 1°
 2 PL: ± 0.010° 3 PL: ± 0.005°
 INTERPRET DIM AND TOL PER ASME Y14.5M - 1994

THIRD ANGLE PROJECTION

DESIGN BY:	RH
DATE:	99/7/19
DRAWN BY:	RH
DATE:	99/7/19
AUTH:	DATE:
AUTH:	DATE:
AUTH:	DATE:
FILENAME:	
\$FILE NAME\$	

deceuninck NORTH AMERICA
 351 NORTH HARVER ROAD
 MONROE, OHIO 45002

NAME: MAIN SASH - CA

SIZE DWG. NO:	10005484	REV.:	J
SCALE:	2:1 (LBS./FT.)	SHEET:	1 OF 1

PL020425

SUSERS

SHEETS

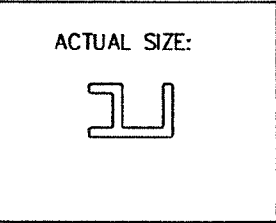
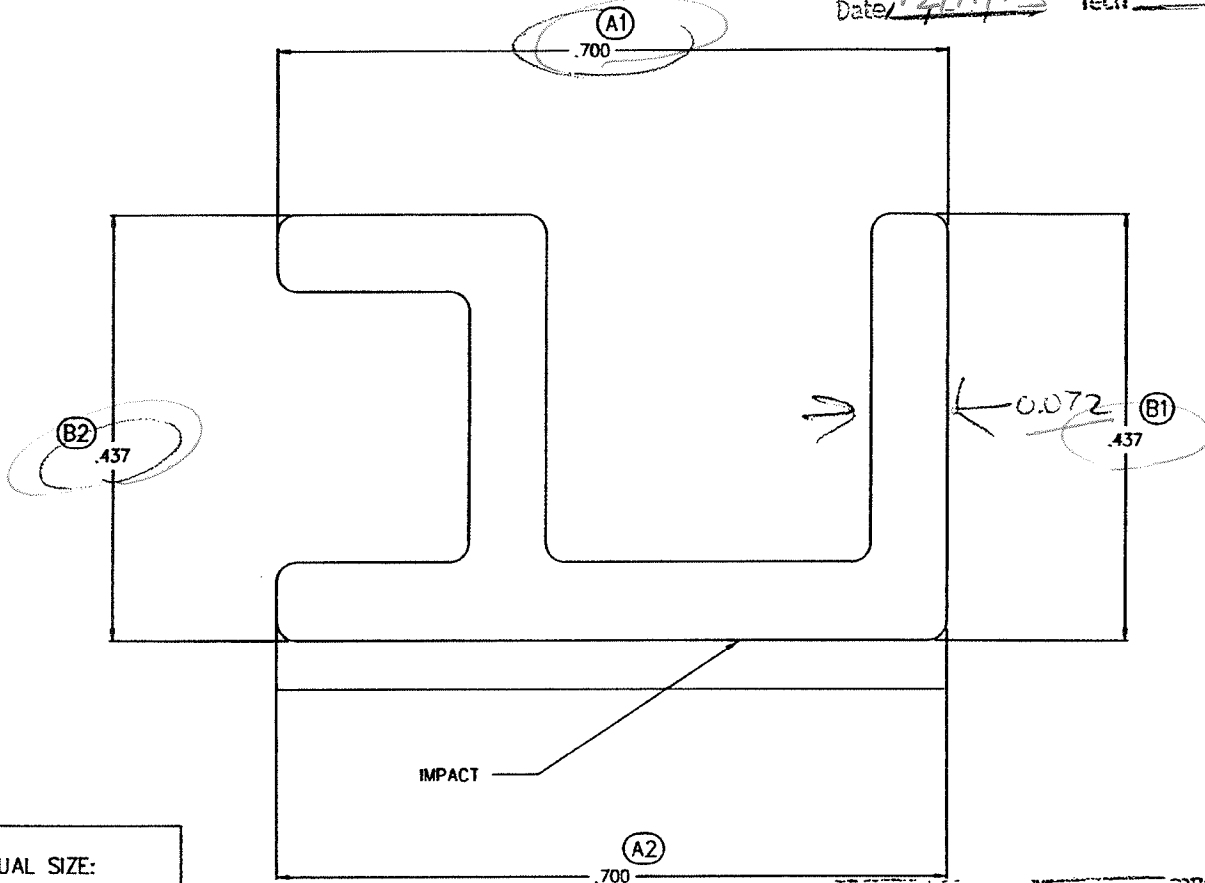
Architectural Testing

UNLESS OTHERWISE NOTED THE FOLLOWING TOLERANCES APPLY
 .001 - .100 * .005 1.001 - 1.500 * .020
 .101 - .500 * .010 1.501 - 2.000 * .025
 .501 - 1.000 * .015 2.001 - & UP * .030
 UNSPECIFIED ANGLES * 1° - WOODGRAIN SURFACES ADD .007

—— = EXPOSED SURFACE ———> = WOODGRAIN SURFACE

Test sample complies with these details.
 Deviations are noted.

Report# D2596.01
 Date 12/11/13 Tech JG.



REV.	DATE	DESCRIPTION	BY
A	9/28/95	NEW TITLE BLOCK	CRB

FITS WITH: N/A

BOW CLASS: B IMPACT AREA: NOTED

CONTROL DIMENSIONS									
DIM	NET	MIN	ENG	MAX	DIM	NET	MIN	ENG	MAX
A	C-0	.670	.700	.730	X				
B	C-0	.422	.437	.452	Y				
C					Z				
D					AA				
E					BB				
F					CC				
G					DD				
H					EE				
I					FF				
J					GG				
K					HH				
L					II				
M					JJ				
N					KK				
O					LL				
P					MM				
Q					NN				
R					OO				
S					PP				
T					QQ				
U					RR				
V					SS				
W					TT				

Part Wt. (lbs/Ft)	Rigid:	Cop:	Flex:	Num:	Total
	.081	----	----	----	.081
	----	----	----	----	----

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 AN ALCOA COMPANY

MONROE, OHIO Copyright 1995

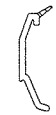
NAME: CASEMENT PICTURE WINDOW SPACER

DRAWN BY: MTC DATE: 2/14/90

CHECKED BY: DATE:

SCALE: 8 : 1 "B" COLOR: W DS EF CW DW

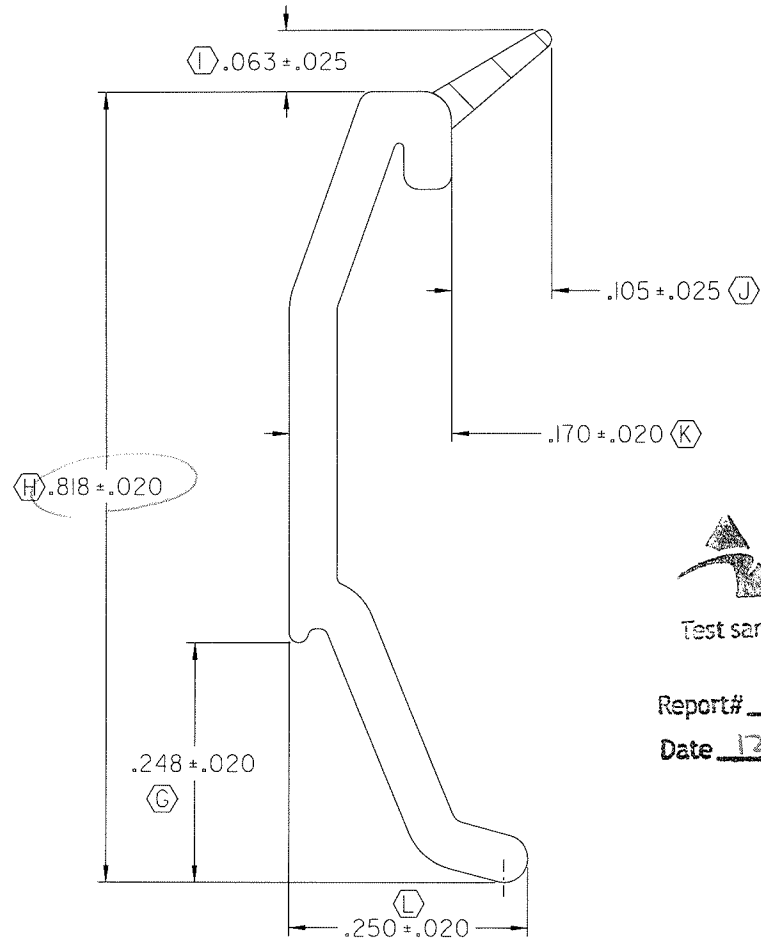
CUST. PART NO. 1200 PART DWG. NO. P1200-A



SCALE 1:1

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
E	UPDATED TO CURRENT STANDARDS	11/01/06	BWB



Architectural Testing

Test sample complies with these details. Deviations are noted.

Report# D2596.01
Date 12/11/13 Tech JG

WALL THICKNESS
.050 -

USE MYLAR 10005473-D

NOTES:

- 'STD00013' STRAIGHTNESS CLASS E AND LENGTH TOLERANCES APPLY (A)
- INTERPRET ALL TOLERANCE APPLICATIONS PER STD0013 (B)
- UNSPECIFIED EXTERNAL RADII = .XXX +.010 / -.005 (C)
- UNSPECIFIED INTERNAL RADII = .XXX +.020 / -.005 (D)
- UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- 10% (E)
- UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- 20% (F)

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UNLESS OTHERWISE SPECIFIED
DIM ARE IN INCHES
TOL ON ANGLES = 1°
2 PL: ± 0.010° 3 PL: ± 0.005°
INTERPRET DIM AND TOL PER
ASME Y14.5M - 1994

THIRD ANGLE PROJECTION



DESIGN BY: PJA
DATE: 99/06/25
DRAWN BY: PJA
DATE: 99/06/25
AUTH: DATE:
AUTH: DATE:
AUTH: DATE:
FILENAME: 106609

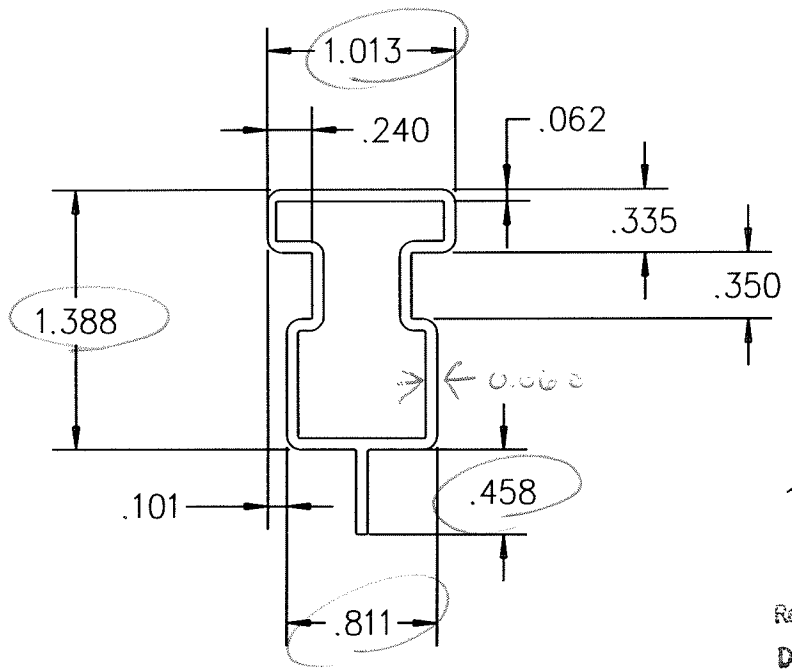
deceuninck NORTH AMERICA
351 NORTH GARVER ROAD
MONROE, LA 70009

NAME: GLAZING BEAD

SIZE DWG. NO: 10005473_SH
REV: E

SCALE: 8 : 1 | LBS/FT.L | .034 | SHEET: 1 OF 1

10/28/2011 usbw 106609.DGN



Architectural Testing
 Test sample complies with these details
 Deviations are noted.
 Report# D2596.01
 Date 12/11/13 Tech YG

- NOTES:
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 2. DAYTON TECHNOLOGIES reserves the right to change specifications.
 3. Material = 6063-T5 Aluminum.

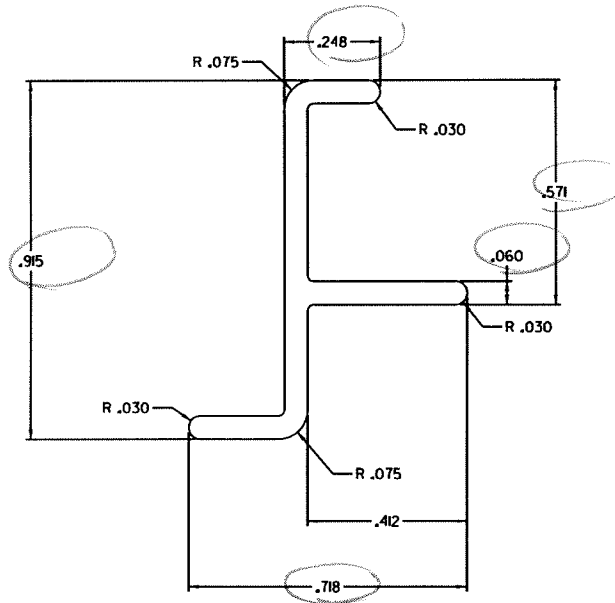
DAYTON TECHNOLOGIES
 MONROE, OHIO Copyright 1999

NAME: Center Bar Reinforcement	
DWN BY: RH	DWG NO: 10300028-A
AUTH:	AUTH. DATE:
DATE: 1/20/00	SCALE: 1 : 1 "A"
PART NO: -	DIE NO: 59928

				AREA:	.327 Sq. In.
				WEIGHT	.394 Lb / Ft.
A	2/7/00	Die Number	RH	Standard Commercial Tolerances	
Rev.	Date	Description	By	Apply Unless Otherwise Noted	

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
B	UPDATED TITLE BLOCK	06/12/04	JGM





Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# D2596-01
Date 12/11/13 Tech JG

ALL UNSPECIFIED RADII SHALL BE .015"

MATERIAL: 6063 - T5 ALUMINUM

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	<p>THIRD ANGLE PROJECTION</p> <p></p>	<p>FILENAME: 10500006.dgn</p>	<p>NAME: CASEMENT REINFORCEMENT</p> <p>SIZE DWG. NO: 10500006 C</p> <p>SCALE: 4:1 (LBS/FT.) J22 SHEET: 1 OF 1</p>

3/76/2007

USP

H:\p\10500006\ALUMINUM\10500006.dgn